

Work Order ID 160193

Thursday, May 04, 2017 9:28:09 AM

160193

Page 1

Item ID: D500-572-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: MD369/MD500 Bearpaws - Narrow

Start Date: 5/4/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/12/2017 Req'd Qty: 4.00

4

Customer:

Reference: REWORK AS PER ECN 17-546

Approvals:

Process Plan:

Date: MAY 04 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2671	Rev B1	MAY 05 2017							

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D500-572-021 CHG007

105

0.00

105

QC

Memo

0.00

Quality Control

PULL FROM STOCK
D500-572-021 X4B: 133508 X1
B: 130068 X1
B: 42331 X2

AA PER ECN 17-546

xy
DAS
27
9-89
MAY 25 2017

MAY 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 160193

Thursday, May 04, 2017 9:28:09 AM

160193

Page 2

Item ID: D500-572-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: MD369/MD500 Bearpaws - Narrow
Start Date: 5/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/12/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: REWORK AS PER ECN 17-546

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging	REMOVE FROM KIT:								
	AN4-15A X 32 B: <u>108868</u> X 24								
	D2182B X 8 B: <u>39980</u>								
	D2438 X 16 B: <u>3994074</u>								
	ADD:								
	AN4-13A X 32								
	D5476-1 X 16								
	D5472-1 X 16								
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

Handwritten notes and stamps:
- Blue stamp: 4
- Blue stamp: 8-8
- Blue stamp: DAS 28 9-85
- Blue stamp: DAS 27 9-85
- Blue stamp: MAY 11 5 2017
- Blue stamp: MAY 25 2017
- Handwritten: X4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 160193

Thursday, May 04, 2017 9:28:09 AM

160193

Page 3

Item ID: D500-572-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: MD369/MD500 Bearpaws - Narrow

Start Date: 5/4/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/12/2017 Req'd Qty: 4.00

4

Customer:

Reference: REWORK AS PER ECN 17-546

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	REPACKAGE UNDER NEW BATCH NUMBER NEW LABEL CHG 007								
	Identify and pack for shipping as per PPPD500-572-021								
	LOCATION: FG014								
	<u>xy</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS DAS
28 27
9-89 9-89

MAY 25 2017

DAS
21
9-89

MAY 29 2017

DAS
21
9-89

MAY 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Picklist Print

Page 1

Thursday, May 04, 2017 9:28:14 AM

Work Order ID: 160193

160193

Parent Item: D500-572-021

D500-572-021

Parent Item Name: MD369/MD500 Bearpaws - Narrow

Start Date: 5/4/2017

Required Date: 5/12/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM
IPP Rev:D 07-01-02 Was K10005 JLM
IPP Rev:E 08-10-14 Added Step 2 JLM Verified By:DD
IPP Rev:F New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A

Purchased

No

Each

528.0000

**

8

32

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

70

m134634

19

m135470

51

over003

200

m137371

200

Return2017

8

m135470

8

ST344

230

m137321

230

AN4-15A

Purchased

No

Each

158.0000

**

32

-32

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

10

120449

10

ST343

148

m137280

148

108868x21

132317x8

DAS
28
9-89

MAY 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Thursday, May 04, 2017 9:28:14 AM

Work Order ID: 160193

160193

Parent Item: D500-572-021

D500-572-021

Parent Item Name: MD369/MD500 Bearpaws - Narrow

Start Date: 5/4/2017

Required Date: 5/12/2017

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No

D2182B

Rubber Cushion - Black (\$Per Foot)

D 2182B 050 x 16

Location

Loc Qty

Loc Code

ST411

34.845

135093

34.845

Each

80.0000

-16

D2438 Manufactured No

D2438

Clamp

Location

Loc Qty

Loc Code

ST542

80

151376

2

152451

24

155069

44

155929

10

Each

0.0000

D500-572-021 Manufactured No

D500-572-021

MD369/MD500 Bearpaws - Narrow

D5472-1

Manufactured No

D5472-1

Cushion

D5476-1

Manufactured No

D5476-1

Clamp

Location

Loc Qty

Loc Code

st533

8

159012

8

16

16

160781

MAY 05 2017

134023x4

39980x12

MAY 05 2017

39940x12

128921x4

4

16

16

MAY 26 2017

MAY 17 2017

DAS 6 9-89

DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 160193

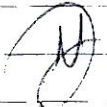
160193

Page 1

Thursday, May 04, 2017 9:28:09 AM

Item ID: D500-572-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: MD369/MD500 Bearpaws - Narrow

Start Date: 5/4/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/12/2017 Req'd Qty: 4.00 *4* Customer:
 Reference: REWORK AS PER ECN 17-546

Approvals: Process Plan:  Date: MAY 04 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2671	Rev B1	MAY 05 2017							
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D500-572-021 CHG007								
105		0.00							
105									
QC	Memo	0.00							
Quality Control	PULL FROM STOCK D500-572-021 X4 B: 133508 X1 B: 130068 X1 B: 42331 X2 AA PER ECN 17-546								

CB

4

MAY 05 2017